



Dart Aerospace Ltd.
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D3564-11

Job Sheet 197146

DAS
21

Part No: D3564-11

Job Qty: 12 pcs

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/26/19

Description:

Type: Stock

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	7/26/19	7/26/19	0.17	2.09	Waterjet - Flow		JRB 7/8/19
120	QC 8	12 pcs	7/26/19	7/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	12 pcs	7/26/19	7/26/19	0.25	0.80	Small Fab - Brake - 1 - B4B		JUL 1 2019
							Small Fab - Brake - 2 -		

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9-89

JUL 0 9 2019



Container No: S196397



Part: D3564-11

Job No: 197146

Serial No/Batch: S196397

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/26/19

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				B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	7/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Automated Welding - B4B	12 pcs	7/26/19	0.00 5.10	Automated Welding - 1 - B4B	
160 QC 10	12 pcs	7/26/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
170 QC 5	12 pcs	7/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Spray Paint - 2 - B4B	12 pcs	7/26/19	0.00 1.20	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
190 QC 5	12 pcs	7/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

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JUL 22 2019

M. Lajeunesse

EL

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18 19-7-25

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200	Packaging 3-1 - Stock - B4B	12 pcs	7/26/19	0.00 0.00	JAS 40 9-89 JUL 29 2019
					Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
210	QC 21 - SA	12 pcs	7/26/19	0.00 0.00	21 9-89 AUG 01 2019
					QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: F Prog Rev: F 2-Deburr if necessary
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - Form on Brake as per Dwg D3564 using Jigs DT8179
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Automated welding) 1- AUTOWELD AS PER DWG AND QSI004 8259 HARDCOAT BATCH: _____
160 - (QC10- Inspect visual per QSI004- ground welds)
170 - (QC5- Inspect part completeness to step on W/O)
180 - (Spray Paint / NDT Room) APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG) **5192286**
190 - (QC5- Inspect part completeness to step on W/O)
200 - (Identify as per dwg & Stock Location: _____)
210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	16.9200 sf (1.41 ea)	100-Waterjet - Flow - 1	5179460 5179460

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	17	265	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches $\pm$ 0.010	3.237 3.217		
2	Wearshoe	2.432inches $\pm$ 0.010	2.442 2.422		
3	Wearshoe	2.500inches $\pm$ 0.010	2.510 2.490		
4	Wearshoe	6.000inches $\pm$ 0.010	6.010 5.990		
5	Wearshoe	12.104inches $\pm$ 0.010	12.114 12.094		
6	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990		
7	Wearshoe	18.000inches $\pm$ 0.030	18.030 17.970		
8	Wearshoe	9.000inches $\pm$ 0.030	9.030 8.970		
9	Wearshoe	11.500inches $\pm$ 0.030	11.530 11.470		
10	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
11	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
12	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187		
13	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365		
14	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053		

Plex 7/2/19 9:13 AM Dart.lajeunesse.marie

Route update only



Job: _____ Part No. _____		DISPOSITION Rework Scrap Use-as-is		DEPARTMENT/PROCESS Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Date :	Sequence #:		QTY Affected :		MRB (QS1042)		
Description Work Order Deviation			Disposition				
Completed By			Lead hand / Supervisor				
QC / QA Coordinator							

Root Cause		FAULT CATEGORY									
Operator	Pressure/Forced	Contamination	Power Loss/ Surge	Positioned Wrong							
Manufacturing Process	Bending	Misaligned/off center	Folio/Program	Outside Tolerance							
Equip/Tooling	Crushing	BOM/Route	Grain Direction	Drawing							
Handling/Preservation	Cracks	Broken/Damage/Defect	Weld	Finish							
Material	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing							
Product Improvement	Marks/Chatter	Drill Holes	Out of Sequence	Misread							
Process Improvement	Mislabeled	Fit/Function	Off-set/Set-up								
Human Factors	Other/Details:										